

Grey

Dart Aerospace Ltd.

Date: Monday, 27/04/2009 12:51:25 PM  
User: Julie Dawson

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPLATE
<b>Job Number</b> : 47536	
<b>Estimate Number</b> : 13309	
<b>P.O. Number</b> :	<b>Part Number</b> : D37911
<b>This Issue</b> : 27/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3791 REVA
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 47210	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 07/05/2009 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09.04.27</u>	
<b>Comment</b> : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 0.3063 sf(s)/Unit Total : 3.6754 sf(s)  
M304S16GA Stainless steel sheet 0.063" thick  
Batch: 11323 IB 9-4-29

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3791  
Dwg Rev: A IB 9-4-29  
Prog Rev: A  
2-Deburr if necessary IB 9-4-29

(15)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5 026462 (15)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

SB 09/05/01 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 27/04/2009 12:51:26 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47536

Part Number: D37911

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Ensure joggle as per dwg D3429

S 02/05/04 (X15)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M11036

2 9-5-4 (X15)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 02/05/04 (X15)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/05/04 (X15)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 109091

START TIME:

8:30

OVEN TEMPERATURE:

320°

FINISH TIME:

9:00

BR 09-05-5 (15)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-05 (X15)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker and Stock

Location:

FR-17

BR 09-05-5 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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User: Julie Dawson

## Process Sheet

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Drawing Name: WEARPLATE

Job Number: 47536

Part Number: D37911

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/05 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

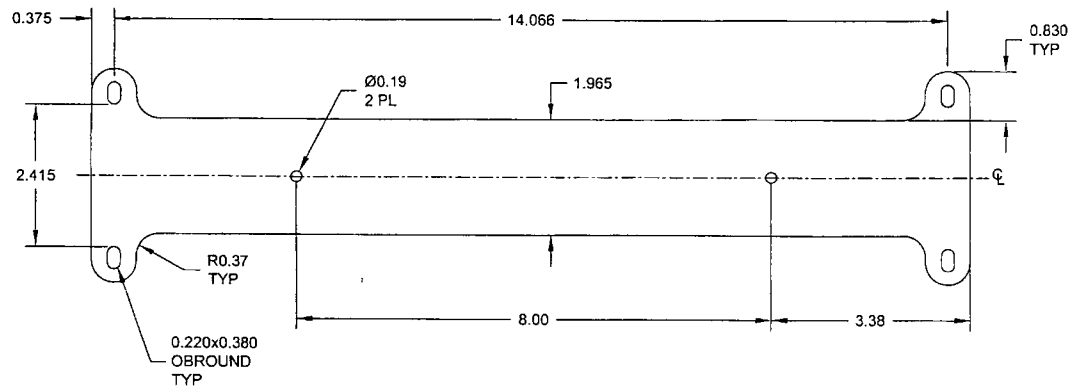
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

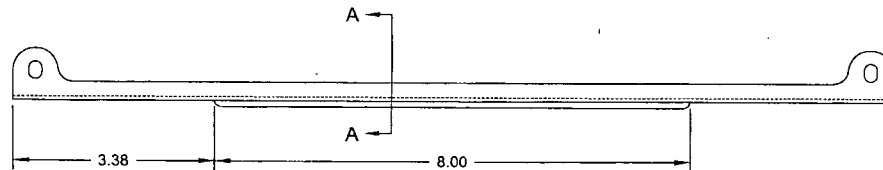
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

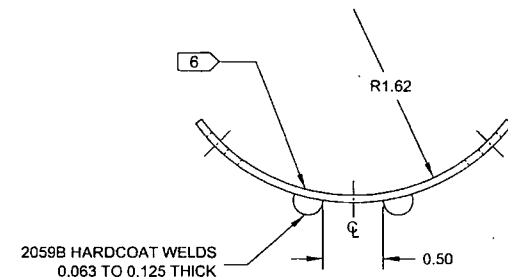




**D3791-1F FLAT PATTERN**



**D3791-1 WEARPLATE**  
(MAKE FROM D3791-1F)



**SECTION A-A**  
SCALE 2X

NO. 1530  
WORK CENTER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

**RELEASED**  
08.05.13

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.13
DESIGN	PH		BY	DATE
DRAWN	PH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.13			

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3791  
TITLE WEARPLATE  
SCALE NTS

REV. A  
SHEET 1 OF 1

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